

Work Order ID 82616***82616****Ship Thursday*

Page 1

Tuesday, April 03, 2012 1:49:38 PM

Item ID: DSI 9464-011

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Tuning

Start Date: 4/3/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/5/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-04-03*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3955

A

DSI 9464

B

100

0.00

100

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001*Sczkur**ML 12/04/04*

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

JB *12/04/04*

Work Order ID 82616***82616***

Page 2

Tuesday, April 03, 2012 1:49:38 PM

Item ID: DSI 9464-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Tuning

Start Date: 4/3/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 4/5/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9464-011								
	Location: _____								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/454 P12

MCS 12/04/04

R12044

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Required Qty: 1.00

IPP Rev:B as per ECN10-553 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3955-041 Doubler Assembly		Manufactured	No			110	Each	4.0000	2	2	13		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		4							
				80620		4							
D3955-3 Cover Plate		Manufactured	No			110	Each	4.0000	2	2	20		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST097		4							
				80621		4							
D3955-5 Plate		Manufactured	No			110	Each	1.0000	2	2	23		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		1							
				69050		1							
D3955-7 Plate		Manufactured	No			110	Each	7.0000	6	6	23		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST071		7							
				80622		7							
D3955-21 Gasket		Manufactured	No			110	Each	10.0000	2	2	23	12/04/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		10							
				67410		2							
				80623		8							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 03, 2012 1:49:37 PM

Page 2

Work Order ID: 82616

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/3/2012

Required Date: 4/5/2012

Start Qty: 1.00

Required Qty: 1.00

D3955-23
Template

Manufactured No

110 Each 2.0000

2

2

JB

JB

Location

Loc Qty

Loc Code

ST077

2

80624

2

80624

38

38

✓

JB

CR3212-4-04
Cherry Rivet

Purchased No

110 Each 5,714.0000

Location

Loc Qty

Loc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

5546

119075

119075

5546

AN3-5A
Bolt

Purchased No

110 Each 1,540.0000

4

4

JB

12/04/04

Location

Loc Qty

Loc Code

ST350

1540

115371

46

117423

124

118626

170

119355

200

120187

500

121185

500

118626

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 82616

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/3/2012

Required Date: 4/5/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-6A Bolt Purchased No 110 Each 362.0000

4 4 JB

Location	Loc Qty	Loc Code
ST351	362	
117441	36	
120498	76	120498
120644	100	
121060	50	
121166	100	

AN3-7A Bolt Purchased No 110 Each 95.0000

4 4 JB

Location	Loc Qty	Loc Code
ST351	95	
117872	95	117872

AN3-10A Bolt Purchased No 110 Each 352.0000

4 4 JB

Location	Loc Qty	Loc Code
GA	48	
119084	48	119084
ST351	304	
117795	4	
120873	300	

NAS1149D0332J Washer Purchased No 110 Each 3,393.0000

6 6 JB 12/04/04

Location	Loc Qty	Loc Code
ST298	3393	
105793	12	
110985	4	
117087	89	
119042	38	
119717	620	
120644	630	120644
121011	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82616

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/3/2012

Required Date: 4/5/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Nut

Purchased

No

110

Each

2,449.0000

2

2

JB

12/04/04

Location

Loc Qty

Loc Code

ST300

2449

117441

16

117885

32

118451

5

118927

3

119017

2167

~~119075~~

166

121162

60

119017

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

REFERENCE ONLY

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skid tubes in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skid tube.

Procedure:

Note: Installer must be careful not to damage underlying skid tube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skid tube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skid tube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skid tube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skid tube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skid tube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:






The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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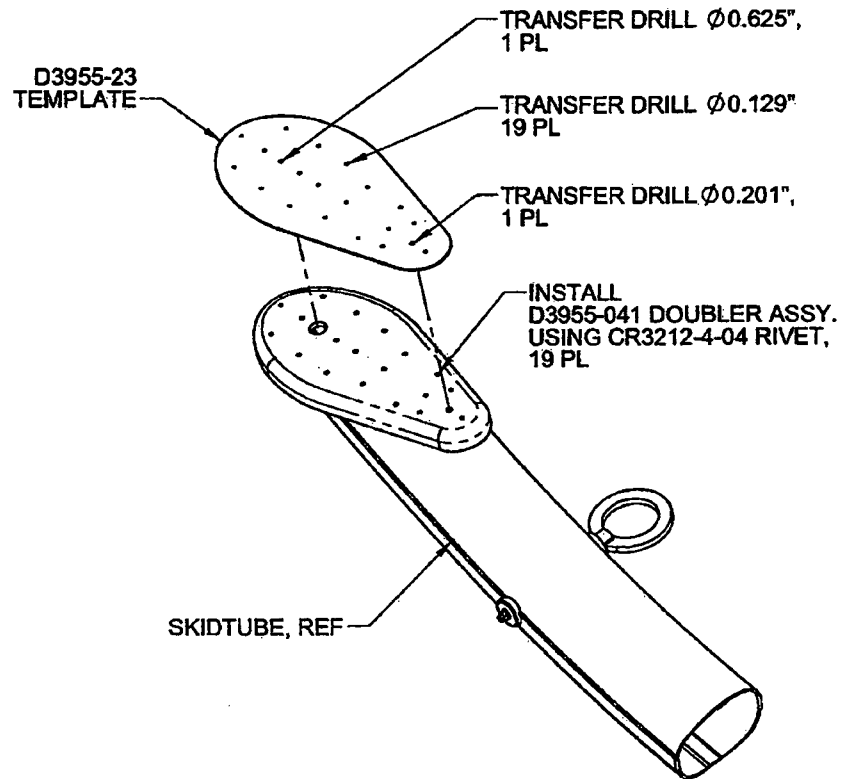


Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9464	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE SKIDTUBE TUNING KIT	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE 10.04.14		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

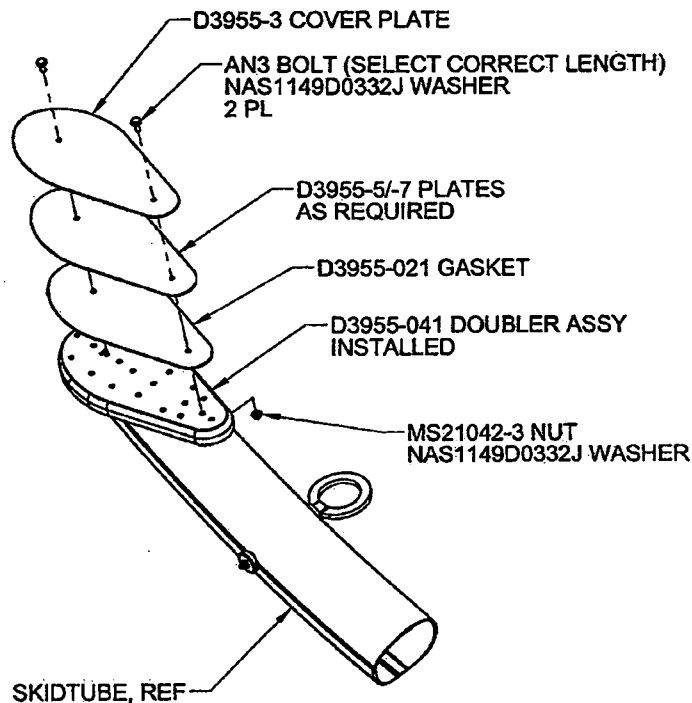


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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